

Work Order ID 80442

80442

Page 1

February-21-12 9:15:24 AM

Item ID: D3806-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 21/02/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/02/12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 44.50"

FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING

75 12-03-04 (K 20)

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB070 & dwg

FOLIO REV: AA

DWG REV: B

2-Deburr as required

smk 12/03/09

20 *

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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

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20

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING

OK 12/03/09

20 0

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B.A 12/03/11

20 0

140

Identify as per dwg & Stock Location: ST WA

0.00

140

Packaging

Memo

0.00

Packaging

(20x) Sp 12-03-12.

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/13/13
H/1203-13

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Picklist Print

February-21-12 9:15:27 AM

Page 1

Work Order ID: 80442

80442

Parent Item: D3806-5

D3806-5

Parent Item Name: Bar

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
IPP Rev:B 08-09-23 redesign DD verified by:EC
IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D
11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased			No		f	491.6000		78.06316			

M304B0 250x0 500

304 BAR .250 x .500

**

12-03-04

Location	Loc Qty	Loc Code
MAT006	491.6	
120696	491.6	

83.291

105" x 2

44.5" x 1

12' 5" x 5

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Dart Aerospace Ltd

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8 7 6 5 4 3 2 1

D

D

D3806-1 BAR

D3806-5 BAR

C

C

D3806-3 BAR

D3806-7 BAR

B

B

RELEASED
2011-10-03
MB

A

A

80442 M.L.J
12/02/21

REV.	B		REVISED D3806-1/3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PART11-108	MB	11.09.29
A	NEW ISSUE			MB	08.11.21
REV.	DESCRIPTION		BY	DATE	
DESIGN	DRAWN		DART AEROSPACE USA, INC. KENT, WA		
CHECKED	MFG. APPR.		DRAWING NO.	REV. B	
APPROVED	DE APPR.		D3806	SHEET 1 OF 3	
DATE	11.09.29		TITLE	SCALE	
			BAR	NTS	
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8 7 6 5 4 3 2 1

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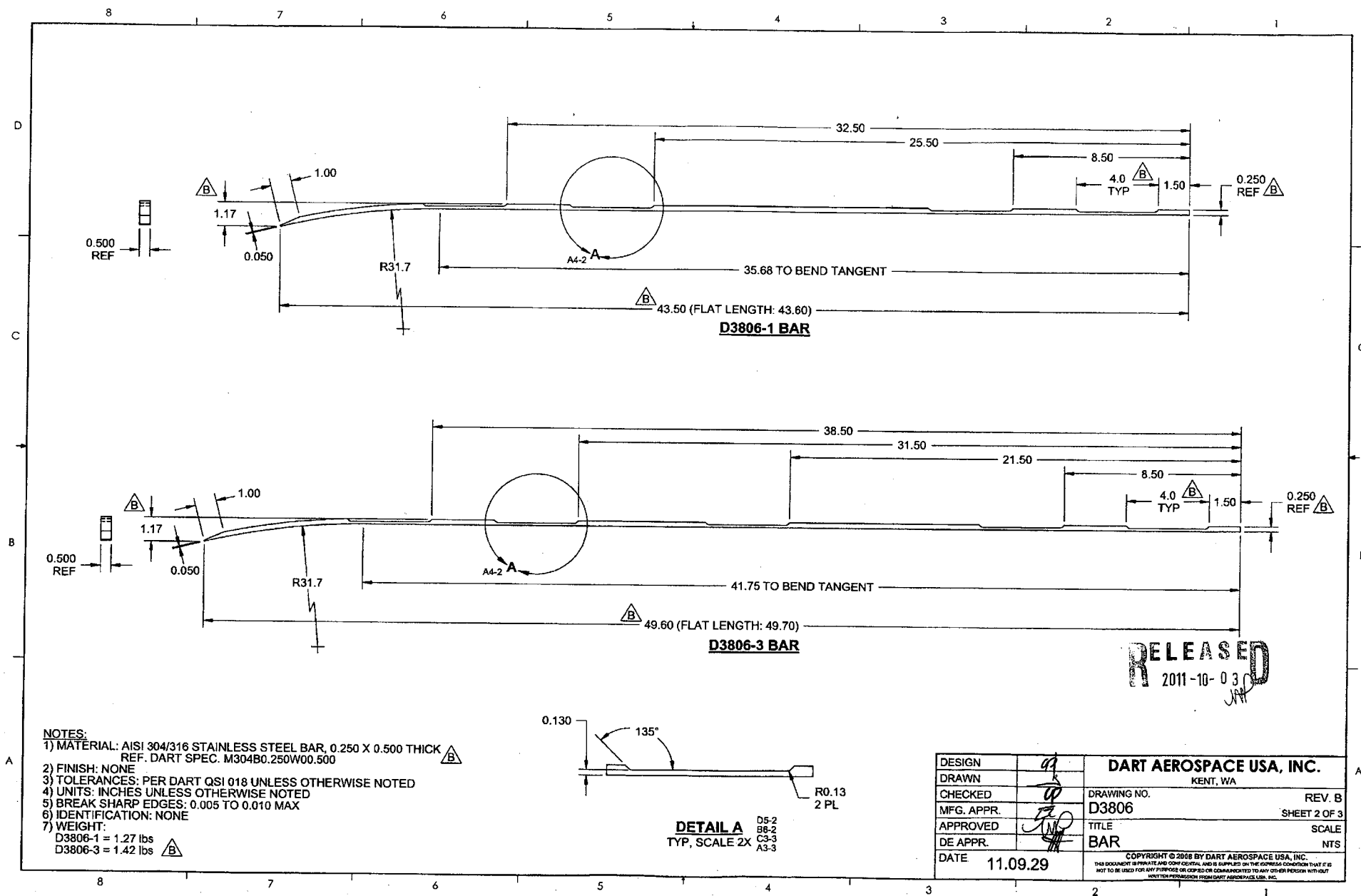
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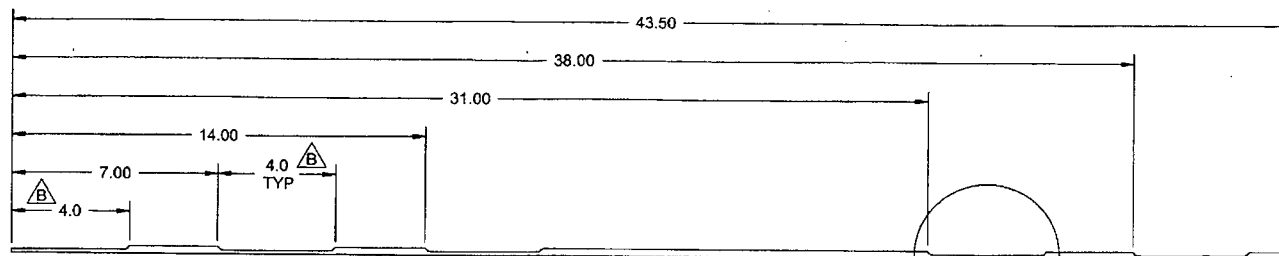
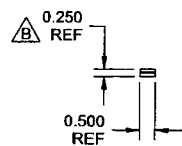
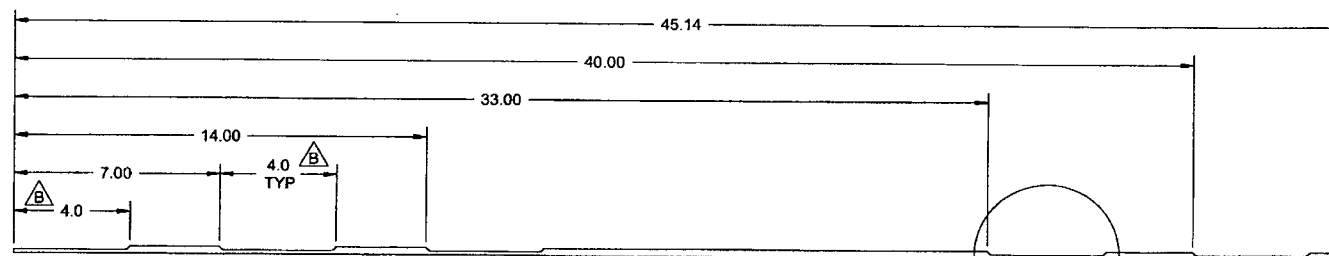
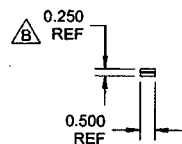
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**D3806-5 BAR****D3806-7 BAR****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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